

# MARGACH

*Automatic*

## Metal Feeder

*The universal feeder  
for all typesetting and  
typecasting machines*



### INSTRUCTIONS

## MARGACH AUTOMATIC METAL FEEDER

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### How to Attach the Margach Feeder to Linotype or Intertype Machines

1. The accompanying photos show how the feeder is attached. The first operation on old machines should be the drilling of  $\frac{1}{4}$  inch hole for the float chain in the pot cover, 2 inches back of chimney. The small chain shown in Fig. A is the float chain. On the Linotype this hole should be drilled about  $2\frac{1}{2}$  inches back of the centre of chimney. All the later models will be found with a hole already in the pot cover through which the chain may pass. On the Intertype drill hole so as to bring float well into the back corner of the pot. On the electric pots a guide plate is fastened under the screw at the front inside corner of pot, and the float rod rides through the slot.

2. The pipe bracket may next be put up. Different makes and models require slightly different details in this bracket, but a study of the illustration will enable anyone to attach without difficulty. The bracket is adjustable to any position and should be perpendicular before feeder is hung on. The strings should not be cut until feeder is on bracket. When feeder is in place hang pigs on hooks and get feeder in such a position that pigs will be well forward in pot. The bracket being adjustable, will enable you to do this.

3. In Fig. B is shown a small arm or lever clamped to the first elevator lever. There are two different styles of these arms (Model 9 arms are 18 inches long) but they are attached so to bring the "eye" through which the operating chain passes in the position shown. The power to operate feeder is taken from this arm. When arm is in position as shown, loop operating chain up "to operating length" (see Fig. 1), and pass end of chain down back of pot (inside the lug) down through eye in arm. Turn machine to casting position and draw chain as far through eye as will go and move up nuts on bolt until chain is tight. IT IS ABSOLUTELY NECESSARY that the operating chain be drawn tight when machine is in casting position. This is the only adjustment, but it must be maintained.

4. The chain may be unhooked above the pot when running pigs down by hand, or when it is desirable to throw feeder out of action entirely.

5. It may be necessary to shorten the float chain two or three links. These can most easily be removed from the upper end. The four holes in float rocker (back of feeder) will give a variation in height of metal without changing length of float chain.

6. Last and again — operating chain must be tight when first elevator is at its lowest point.

#### ADDITIONAL INSTRUCTIONS

On MODELS Nos. 1, K and L of the Linotype, the pipe brace will be as shown in Fig. C, and the pot pump spring has to be removed to attach bracket. On the other models, the pipe bracing is set off at an angle so that a rotating well brush can be used without hindrance.

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On Models 9 and 24 and all 42-em Linotypes, the arm that operates the chain is attached to the first elevator where the Shaft goes through, then follow directions as described in Paragraph 3 of previous page.

On INTERTYPE machines, all models are identical so far as attaching the feeders are concerned, their only difference with the Linotype being that the angle of pipe bracket is different, the elbows being set so that they almost touch the pot pump spring. The 42-em machine operating arm, however, is attached similar to model 9 in above.

On LUDLOW TYPOGRAPHS, after the feeder has been attached per description Fig. E, hang up the float chain in one of the four holes in the latch on the side of feeder, using the one giving desired height of metal in pot. If float chain is too long, take off one or two links at the top.

You are then ready to set the long operating chain properly, which is done by turning over the fly-wheel until the two forks under the bed of the Ludlow are at their lowest point (first having attached the operating arm with hole in rod facing the back of machine), then draw bolt through hole and bring up the nuts until fairly tight. You are then ready to proceed, except that you may have to reset the float chain to get the desired height of metal in pot after you have begun using the large pigs. When machine is in home position, there should be about one inch slack between the locknuts on operating chain and hole of operating arm.

On ELROD CASTERS, descriptions of which are on Figs. G and H, show the new friction type of feeder, doing away with operating arms as was used on the old Elrods.

On Fig. G you will note the two brackets that are applied where the screw holes are already tapped for these fittings, and when these brackets are applied you may slide the pipe through the upper bracket and this will guide it into the centre of the lower bracket. The set screws need not be fastened until the feeder has been hung and adjusted so that the pig of metal hangs directly into the opening of the pot.

The operation of this friction feeder is controlled by the float, the hook at one end of the chain being hung in one of the holes of the rocker which operates the pawl against the brake. This type of feeder is very easily adjusted after you hang the pig of metal, and the only requirement for attention is to see that the metal pot is kept full, at which time the float should permit the pawl to lock the brake.

To briefly summarize the aforementioned instructions, in order to attain the desired results, it is necessary, at each revolution of the typesetting machine, that the sliding weight on side of feeder raises above the latch so that the float chain, which hangs from this latch, will freely perform its duty. This is the reason we particularly note to make fairly tight the operating chain by screwing up the nuts on bolt when operating lever is at its lowest point.

## How to Attach Margach Feeder to the Monotype

Fig. D shows the new friction type of feeder applied to the Monotype composition machine and the Monotype Material caster. The Monotype Giant machine and late model Material machines have a "boss" cast to the Swing Frame into which the pipe for the feeder sets, which eliminates the need for our bracket.

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## MARGACH AUTOMATIC METAL FEEDER

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**Costs Absolutely Nothing to Maintain**

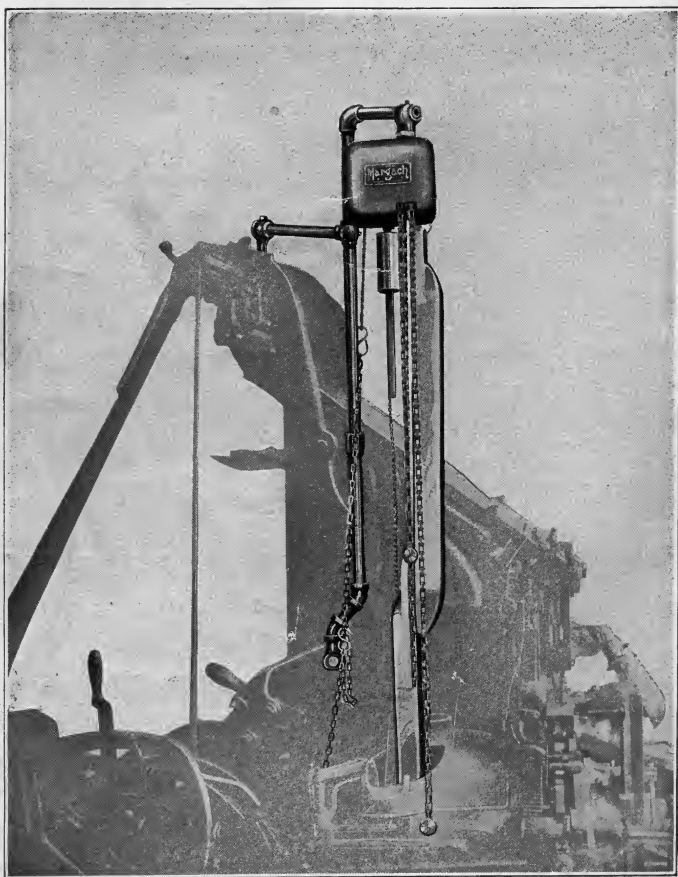


Fig. A

*Feeder applied to either Linotype or Intertype*

## MARGACH AUTOMATIC METAL FEEDER

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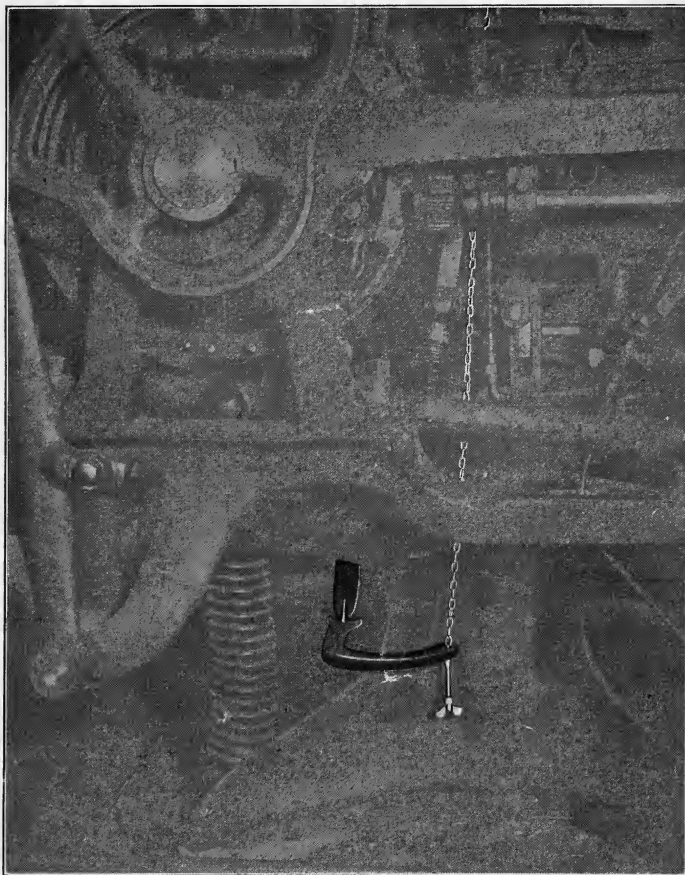


Fig. B

*Clamp applied to Linotype or Intertype First Elevator Arm, When  
Machine is in Home Position*

## MARGACH AUTOMATIC METAL FEEDER

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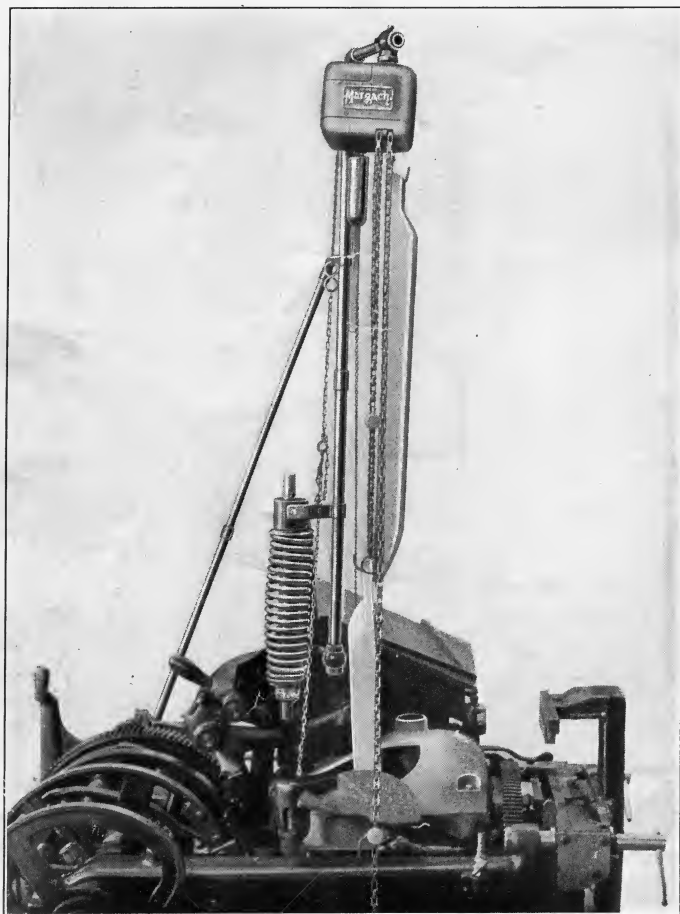


Fig. C

*Margach Feeder as applied to Linotype Slug and Rule Caster*  
(Bracket at lower end of piping is also the same for Model 1 and K.)

## MARGACH AUTOMATIC METAL FEEDER

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*This pawl releases or stops feeding of pig, controlled by float resting in metal pot →*

*Bracket upon which pipe rests on composition machines, and all material making machines built prior to 1928 →*

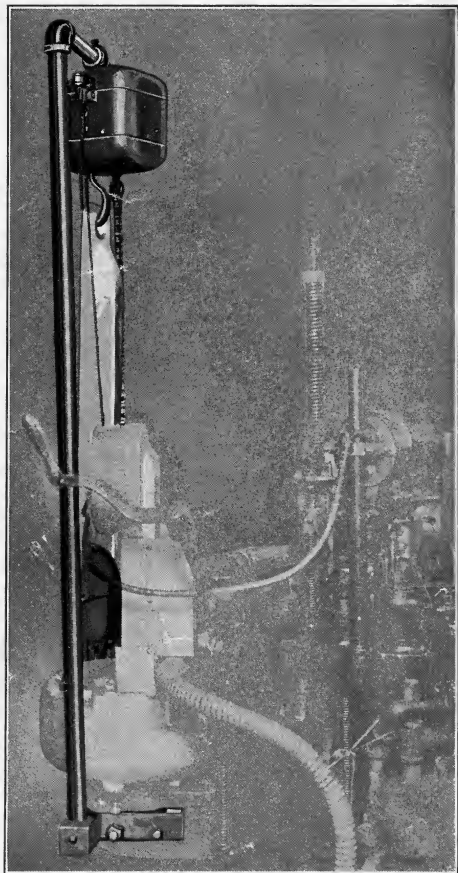


Fig. D

## MARGACH AUTOMATIC METAL FEEDER

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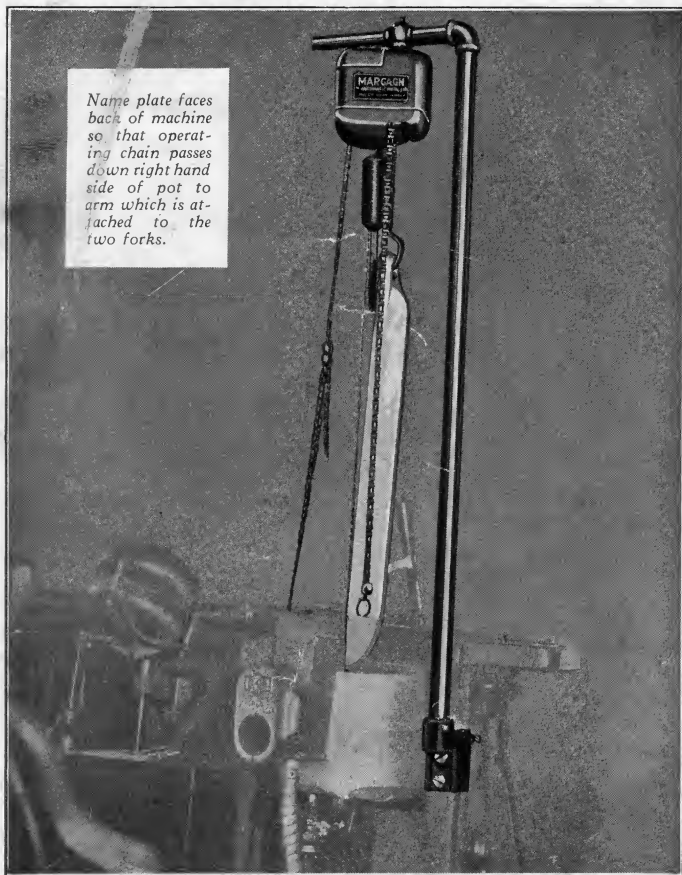


Fig. E

### LUDLOW

*Bracket and appearance of feeder from rear of Ludlow*



## MARGACH AUTOMATIC METAL FEEDER

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Fig. F

LUDLOW

*Operating arm applied to Ludlow. (View from front of machine)*

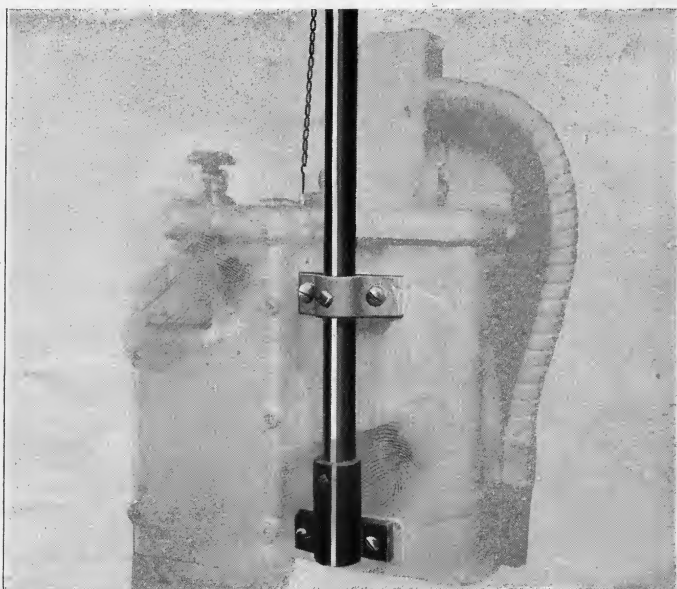


Fig. G

*Brackets applied to New Elrod Pot*

## MARGACH AUTOMATIC METAL FEEDER

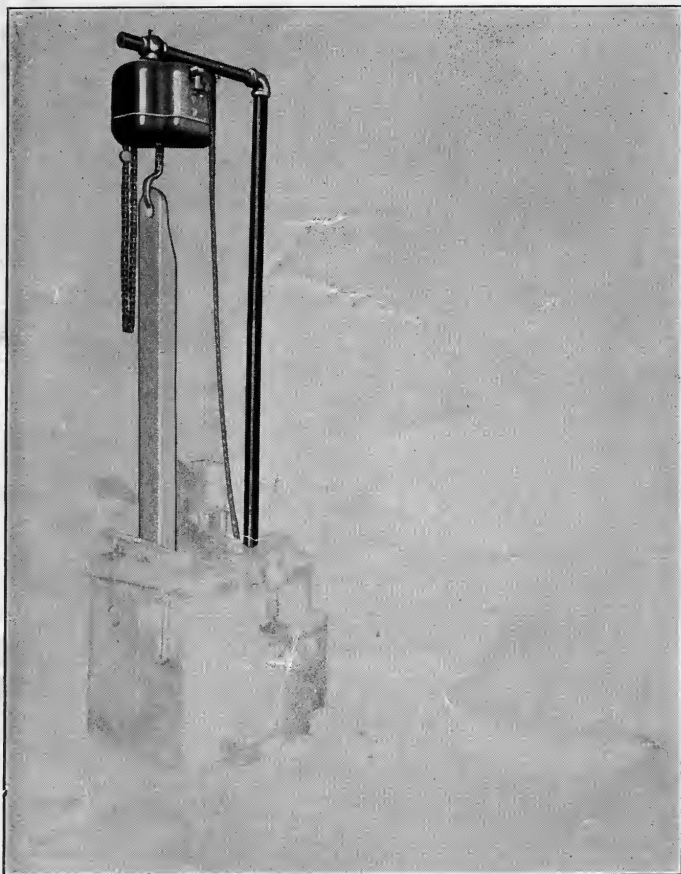


Fig. H

ELROD

## MARGACH AUTOMATIC METAL FEEDER

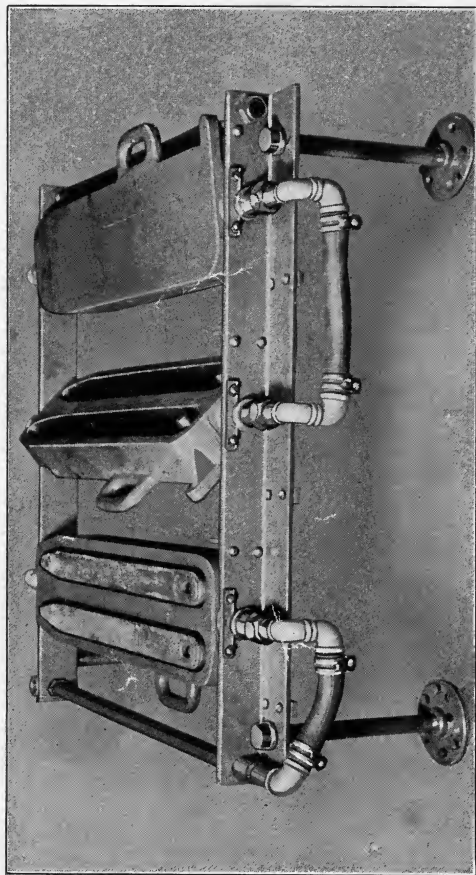
Dimensions, 6 Ingots—38 in. x 41 in.

4 Ingots, 27 in. x 41 in.

This side against Furnace where automatic pouring is used

Outlet

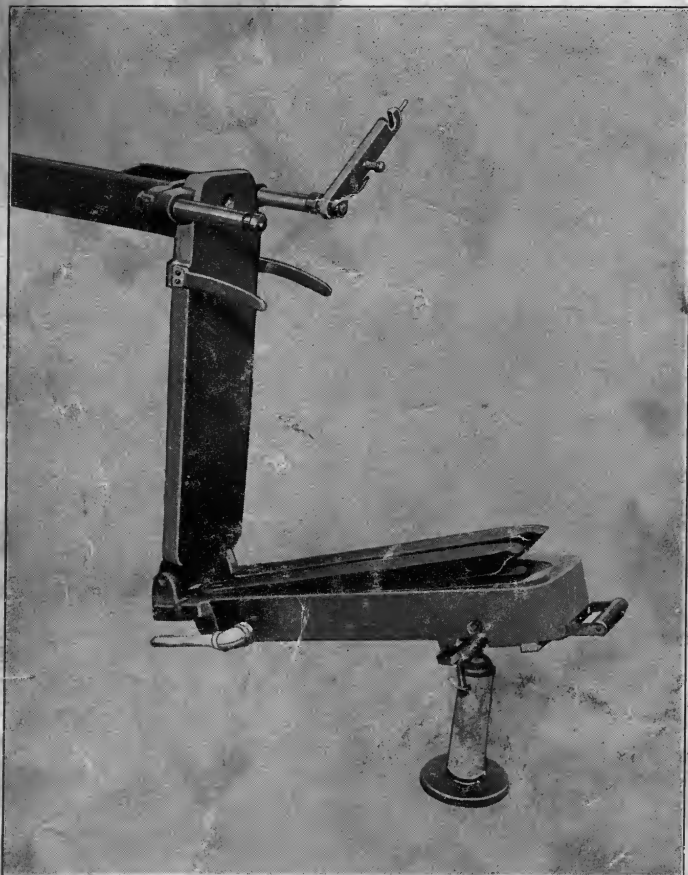
Inlet



*Water-Cooled Mold with 6 Ingots. Also made with 4 Ingots.  
These Molds are made any desired height from floor.*

# MARGACH AUTOMATIC METAL FEEDER

TWO INGOT REPIGGING MOLD  
FOR HOE PUMP



(Open)

*This outfit is readily applied to standard Hoe pump*